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## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 76970

**\*76970\***

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Thursday, November 24, 2011 1:32:37 PM

Item ID: D2672 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bearpaw 13" X 24", 206  
 Start Date: 11/24/2011 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 12/5/2011 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		B.A 12/02/22		4	0		
180 <b>*180*</b> Packaging Packaging	Identify as per dwg & Stock Location: _____ Packaging  Memo	0.00  0.00		PPP 76972					4x SP 12-02-27.
190 <b>*190*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							12/2/27 [Signature]  12-02-27 (4)

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# Picklist Print

Thursday, November 24, 2011 1:32:41 PM

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Work Order ID: 76970

\*76970\*

Parent Item: D2672

\*D2672\*

Parent Item Name: Bearpaw 13" X 24", 206

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 4.00

Required Qty: 4.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	539.2000	3.6	14.4			

\*MUHMWB10\*

UHMW 1" Black

\*\*

B12-1-12

### Location

### Loc Qty

### Loc Code

MAT018

539.2

120035

117321

74.6

117738

124.3

117819

99.3

118814

39

119145

202

④

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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	26970
Description: Bearpaw		Part Number:	D2672
Inspection Dwg: D2672 Rev: B1		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	23.750	+/-0.030	23.75	✓		Tagg FK-05	
B	12.750	+/-0.030	12.75	✓		" "	
C	4.250	+/-0.010	4.250	✓		FK-04	Vern.
D	2.000	+/-0.030	2.000	✓		" "	"
E	9.000	+/-0.010	9.000	✓		CNC-02	Vern.
F	0.375	+/-0.030	.380	✓		FK-04	Vern.
G	9.000	+/-0.010	9.000	✓		CNC-02	Vern.
H	Ø0.260	+0.005/-0.000	.260			FK-04	Vern.
I	Ø0.93	+/-0.030	.929			FK-04	<del>Depth gauge</del> Vern.
J	0.300	+0.030/-0.000	.300			FK-06	Depth gauge
K	0.625	+/-0.030	.647			FK-04	Vern.
L	0.063 x 45°	+0.030/-0.010	.063 x 45°			"	"
M	0.250	+/-0.010	.260			"	"
N	5.500	+/-0.030	5.500			"	"
O	R0.250	+/-0.030	R.250			rad gauge	
P	0.200	+/-0.030	.198			FK-06	Depth gauge
Q	0.25 x 45°	+/-0.030	.25 x 45°			FK-04	Vern.
R	0.950	+0.030/-0.010	.968			"	"
S	0.375	+/-0.010	.385			"	"

Measured by:	FK Long	Audited by:	B.A	Prototype Approval:	N/A
Date:	12/02/22	Date:	12/02/22	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	

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SHOP COPY

RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO APPROVAL  
WITHOUT NOTICE  
WORK ORDER

NO. ENGRAVE LOGO TO  
MAX DEPTH OF  
0.012. ENGRAVE  
PART AND BATCH  
NUMBERS TO MAX  
DEPTH OF 0.010.  
(TYPICAL LOCATION  
AS ILLUSTRATED)

**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	REV. B
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2672	SHEET 1 OF 2
DATE 98.05.19	TITLE BEARPAW	SCALE 1:5	
A	97.04.08	NEW ISSUE	
B	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	
B1	02.10.22	$\phi 0.93$ WAS $\phi 0.75$	

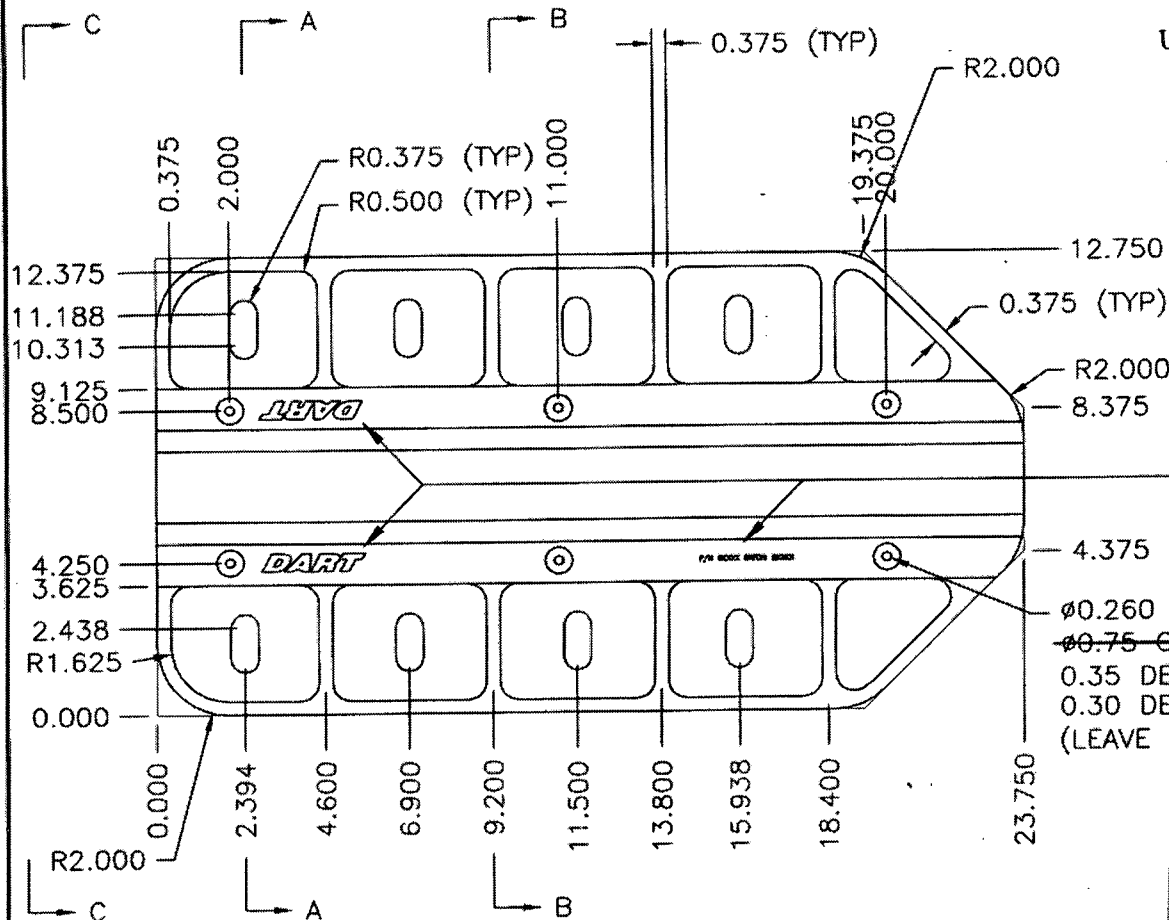


$\phi 0.260$  (TYP)  
 ~~$\phi 0.75$  C'BORE~~  $\phi 0.93$  C'BORE  
0.35 DEEP FROM TOP (MIN.)  
0.30 DEEP FROM BOTTOM  
(LEAVE 0.300 MIN.)

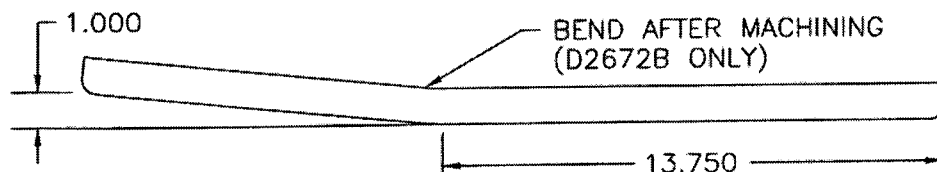
EFFECTIVE

DEOS

**RELEASED**  
98.06.17 KE



FLAT PATTERN



D2672F: FLAT BEARPAW  
D2672B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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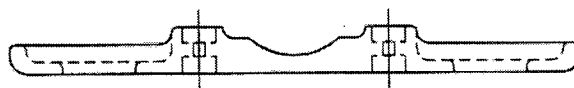
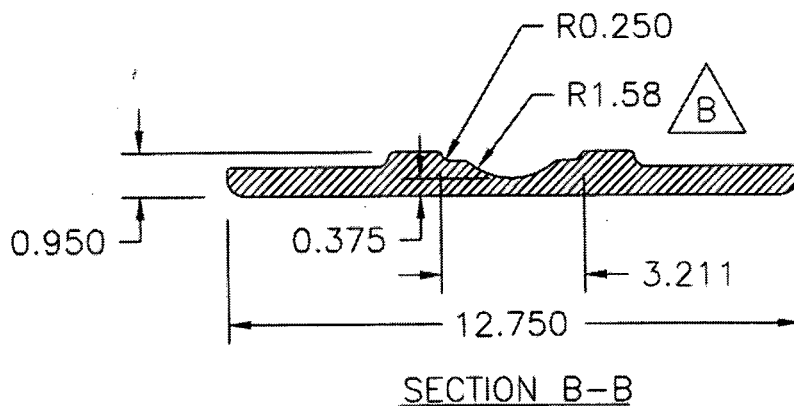
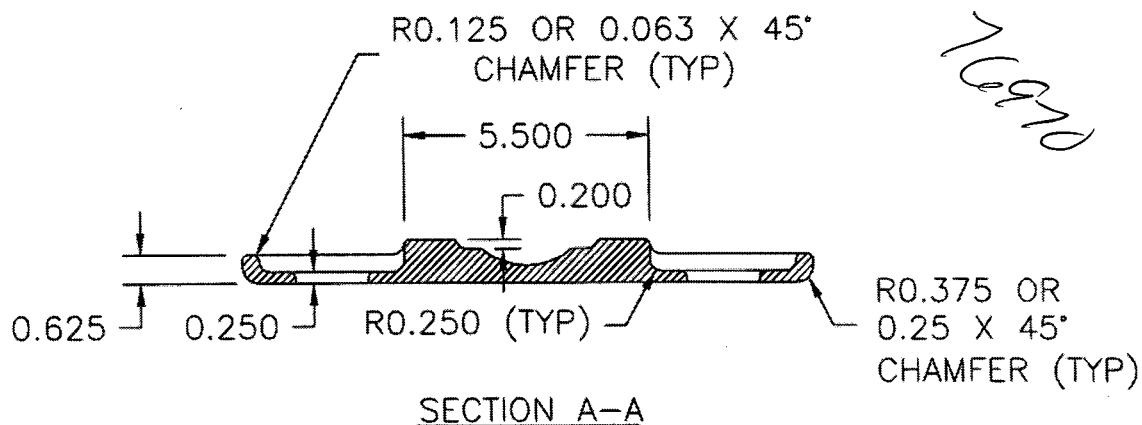
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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2672	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED  
98.06.17 KE



SECTION C-C

W/O:		WORK ORDER CHANGES					
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